

Work Order ID 51543

August 25, 2009 1:36:10 PM



Page 1

Item ID: D3012-5

Accept



Setup Start



Revision ID: A

Stop



Item Name: Decal

Start Date: 8/28/09 Start Qty: 12.00



Cust Item ID:

Required Date: 8/31/09 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: *RL*

Date: *09-8-25* Tooling:

Date:

Stop



QC:

Date: SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3012

Rev A

100

0.00



PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 10259

Make as per Dwg D3012

Manufacture from 3M 7mil masking film p/n 8522CP

Material release note is required

CY 09/08/26 (12)

110

0.00



Receive & Inspect for Damage & Mat'l Certs

Packaging

Memo

0.00

Packaging

Ensure Material Release Note is attached

P 09/08/28/12

120

0.00



QC6- Inspect dimensions to drawing

QC

Memo

0.00

Quality Control

2) 808/09/31

(412) 4

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>UP</i>	DRAWN BY <i>UP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3012	REV. A SHEET 1 OF 1
DATE 01.03.30		TITLE DECAL	SCALE 1:1
A	01.03.30	NEW ISSUE	

RELEASED
01.04.06 *#*

- POINT A -
SWL=300lb/136kg
DO NOT USE WITH POINT B
P/N D3012-1

D3012-1

- POINT B -
SWL=500lb/227kg
DO NOT USE WITH POINT A OR C
P/N D3012-3

D3012-3

- POINT C -
SWL=300lb/136kg
DO NOT USE WITH POINT B
P/N D3012-5

D3012-5

5154/3

MATERIAL: WHITE LETTERS ON BLACK ADHESIVE BACK
MANUFACTURED FROM 3M 7 MIL MASKING FILM #8522CP

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO10259**

Purchase Order Date 8/26/09

PO Print Date 8/26/09

Page Number 1 of 1

Order From :

VC-STU001

STUDIO DE LETTRAGE 2001
210 MAIN WEST
HAWKESBURY, ON K6A 2H6
CA

FAKED

Contact Name

Vendor Phone

613 632 5449

Vendor Fax

613 632 9491

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D3012-1P A	Decal	8/31/09 Yes	30.00 Each	Yours ppd	\$3.7500	\$112.50
Special Inst:			AS PER DWG D3012 REV. A B51542				
2	D3012-5P A	Decal	8/31/09 Yes	12.00 Each	Yours ppd	\$3.7500	\$45.00
Special Inst:			AS PER DWG D3012 REV. A B51543				

PO Total:

\$157.50

**CERTIFICATE OF CONFORMITY
REQ'D UPON DELIVERY**

Change Nbr: 1

Change Date: 8/26/09

No substitution or deviation without
consent.

Certificate of Conformity or Material
Certification required when applicable



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3012	REV. A SHEET 1 OF 1
DATE 01.03.30		TITLE DECAL	SCALE 1:1
A	01.03.30	NEW ISSUE	

RELEASED
01.04.06 *#*

- POINT A -
SWL=300lb/136kg
DO NOT USE WITH POINT B
P/N D3012-1

D3012-1

- POINT B -
SWL=500lb/227kg
DO NOT USE WITH POINT A OR C
P/N D3012-3

D3012-3

REFERENCE ONLY

- POINT C -
SWL=300lb/136kg
DO NOT USE WITH POINT B
P/N D3012-5

D3012-5

REFERENCE ONLY

51543

MATERIAL: WHITE LETTERS ON BLACK ADHESIVE BACK
MANUFACTURED FROM 3M 7 MIL MASKING FILM #8522CP

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Scotchcal™

Opaque Imaging Media 8522

Description

This media is specially formulated to dry quickly after printing. Production of outdoor weatherable and long-term indoor durable graphics is now easier than ever. Its changeable adhesive allows easy removal for up to one year.

Advantages

- Optimized for use with selected Epson Stylus Pro printers and Epson Archival inks.
- Optimized for use with selected HP DesignJet Printers and HP DesignJet Ink System UV or HP83UV Color Ink System
- For making opaque, laminated graphics that are outdoor weatherable and long-term indoor durable
- Media:
 - For opaque (reflective) graphics
 - Changeable, easy to remove from warranted substrates up to 1 year later
 - Dries quickly after printing so the overlamine can be applied almost immediately
 - Low slippage paper liner for superior tiling
- Overlaminates:
 - Provide additional UV (ultraviolet) and physical protection for making weatherable finished graphics
 - Available in luster and matte gloss
 - Adhesive allows for heat-assisted or cold-temperature lamination

Applications and Uses

3M™ Scotchcal™ Changeable Opaque Imaging Media 8522 is intended only for ink jet printing and for use with the listed Compatible Products and Equipment and the following applications. Any other application is NOT warranted by 3M or covered by the worldwide 3M™ MCS™ Warranty unless 3M gives its prior written approval for the application.

- First surface images (the image is on top of the film) for opaque posters and signs, including:
 - Graphics for vans, personal vehicles, trucks and buses
 - Novelty posters
 - Retail and point-of-purchase displays
 - Information graphics such as maps and directories
 - Entertainment promotions in museums, zoos, parks, theatres, sports venues
 - Education and presentation graphics

- Legal and courtroom exhibits

- For flat or simple curved surfaces, with or without rivets, used in vertical ($\pm 10^\circ$) applications

Limitations of End Uses

The following uses and applications are specifically NOT warranted.

- Fleet applications in areas that use salt for winter road maintenance
- Application to non-warranted substrates, including wall-board
- Applications subjected to gasoline vapors or spills
- Application to corrugated or highly irregular surfaces or sharply raised areas
- Graphics applied to stainless steel, including stainless steel vehicles
- On flat surfaces with rivets, tenting of 4 to 10 mm around rivets may be expected; rivets may be cut around to eliminate tenting.

Note: Standard ink jet technology is water based. Water-based chemistry is susceptible to the extremes of heat and humidity. This is a factor in most product constructions on the market. Read the Fabrication, Shelf Life and Storage sections in this bulletin. Staying in the middle of these ranges always provides optimum performance.

Compatible Products and Equipment

Thermal Ink Jet Printing Systems

- Epson Stylus Pro 9500, Stylus Pro 10000 printer
 - Epson Archival Inks
- Epson Stylus Pro 10600 printer
 - Epson Archival Inks
- HP DesignJet Printers 2000 and 3000 series
 - HP DesignJet Ink System UV (pigment-based ink)
- HP DesignJet Printers 5000 series
 - HP83UV Color Ink System

Overlaminates (required)


- 3M™ Luster Overlamine 8519 (semi-gloss)
- 3M™ Matte Overlamine 8520

Note: For the full product names of the 3M products listed on this page, please see page 1.

Shelf Life and Storage

- 3M™ Scotchcal™ Changeable Opaque Imaging Media 8522 has a shelf life of one year.
- Storage conditions (new and partially used rolls). For optimum performance, use the middle of these ranges:
 - Original packaging, including plastic wrap
 - Relative humidity of 20% to 80%
 - Temperature of 33° to 104°F (0° to 40°C)
 - Away from direct sunlight
- Do not stack unprotected rolls or lay sharp or heavy objects on them.

Health and Safety

 **Caution**

When handling any chemical products, read the manufacturers' container labels and the Material Safety Data Sheets (MSDS) for important health, safety and environmental information.

To obtain MSDS sheets for 3M products:

- By fax, call 1-800-364-0768 in the US and Canada or 1-650-556-8417 for all other locations.
- Electronically, visit us at <http://www.3M.com/msds>.
- By mail, or in case of an emergency, call 1-800-364-3577 or 1-651-737-6501.

When using any equipment, always follow the manufacturers' instructions for safe operation.

Warranty and Limited Remedies

3M™ MCS™ Warranty for Graphics Produced on HP DesignJet Printers and Epson Stylus Pro Printers

The following is made in lieu of all other express or implied warranties, including any implied warranty of merchantability or fitness for a particular purpose: We warrant graphics produced by a 3M Ink Jet Registered Fabricator made with imaging media 8522, printed on an approved HP thermal ink jet printer according to HP's recommendations or Epson Stylus Pro printer according to Epson's recommendations, overlaminated with 8519 or 8520, and applied to a Warranted Substrate according to 3M's recommendations. These

3M

Commercial Graphics Division
 3M Center, Building 220-6W-06
 PO Box 33220
 St. Paul, MN 55133-3220 USA
 General Info: 1-800-374-6772
 Technical Info: 1-800-328-3908
 Fax: 1-651-736-4233
 Fax-on-Demand: 1-800-364-0768 U.S./Canada or 1-651-732-6506 International
 Fax-on-Demand document: 4506
www.scotchprint.com

3M Canada
 P.O. Box 5757
 London, Ontario
 Canada N6A 4T1
 1-800-265-1840
 Fax: 519-452-6245

3M México, S.A. de C.V.
 Av. Santa Fe No. 55
 Col. Santa Fe, Del. Álvaro Obregón
 México, D.F. 01210
 52-55-52-70-04-00
 Fax: 52-55-52-70-22-77

3M Puerto Rico, Inc.
 Puerto Rico Industrial Park
 P.O. Box 100
 Carolina, PR 00986-0100
 787-620-3000
 Fax: 787-750-3035

graphics are covered against failure caused by ultraviolet light, temperature extremes, pollution, and other elements.

If a graphic fails to perform in accordance with 3M product specifications within this time frame, 3M will replace the materials at no charge. **These remedies are exclusive. In no case shall 3M be liable for any direct, indirect, or consequential damages, including any labor charges.**

3M Related Literature

Listed below is related 3M technical literature that may be of interest. You may view and print these Bulletins from our Web site at www.scotchprint.com, or order them via our Fax-on-Demand (FOD) system. Call one of these phone numbers to order the desired bulletins, and specify the FOD document number provided in the chart.

United States or Canada: 1-800-364-0768
 International: 1-651-732-6506

Subject	Bulletin No.	FOD No.
Product Bulletins		
3M™ Scotchcal™ Overlamine 8519 and 8520	8519/8520	4524
Instruction Bulletins		
Making thermal ink jet graphics	4.23	6523
Application, substrate selection, preparation and substrate-specific application techniques	5.1	7001
Warranties		
Worldwide 3M™ MCS™ Warranty Packet (includes all Commercial Graphics MCS Warranties)		9503
Worldwide 3M™ MCS™ Warranty Overview-Folder		9504

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 HP and DesignJet are tradenames of Hewlett Packard.
 Sintra is a trademark of Swiss Aluminum Ltd.
 Intron is a registered trademark of DuPont in the United States*

Bulletin Change Summary

The Epson Stylus Pro Printers 9500, 10000 10600, and Epson Archival Inks have been added to this bulletin. Additional changes resulting from this addition are marked with black bars in the margin.



210 MAIN W.,
HAWKESBURY, ONT. K6A 2H6
Tel.: 613 632-2001
Fax: 613 632-9491
www.studioletrage.com

INVOICE / FACTURE

VENDU À:
SOLD TO:

LIVRÉ À:
SHIPPED TO:

No.:
DATE:
PAGE

12638
08/27/2009

1 of 1

Re: Quote No. 7495

Dart Aerospace Ltd
1270 Aberdeen
Hawkesbury, Ontario K6A 1K7

Dart Aerospace Ltd
Hawkesbury, Ontario

ITEM ARTICLE	QTY QYE	UNIT UNITÉ	DESCRIPTION	GST TPS	PST TVP	UNIT PRICE PRIX UNITE	AMOUNT MONTANT
	30 12 1		D3012-1P set up D3012-5P set up printing E - GST @ 5% G - GST @ 5%; PST @ 8% GST PST Exempt: #6122-5207	E E G		1.6667 4.1667 50.0000	50.00 50.00 50.00 7.50
Studio de Lettrage GST #869034678RP001						TOTAL	157.50
PO 10259							
Sold By:							